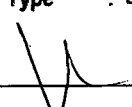
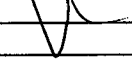


Date: Thursday, 12/20/2007 12:13:54 PM
 User: Dominique Dube

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : PB67-43001-31
Job Number : 36349	
Estimate Number : 10804	
P.O. Number :	Part Number : PB674300131
This Issue : 12/20/2007 S.O. No. :	Drawing Number :
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 1/5/2008 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

ISSUE TRAVELER

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

CUT B67-43001-321 AS PER DWG 24.610" X 2.50"

0.090" THK 6061T6 B 19059 B 07-12-21B 8-1-8

DE-BURR

①

3.0	M6061T6S090
-----	-------------



Comment: Qty.: 0.45600 sf(s)/Unit Total : 0.45600 sf(s)
 6061-T6 .090 Sheet

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-12-21 B 8-1-8

5.0	QC8	SECOND CHECK
-----	-----	--------------



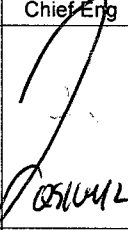
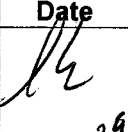


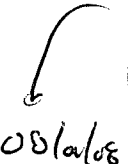
Comment: SECOND CHECK

5 02/12/24 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/06		Scrap two parts. Broke when bending too tight a radius. PC: Hammer error		Scrap and destroy and Replace Qty (2) B.M. 18055	 08.01.29	 08/01/29		 08/01/06

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 12:13:54 PM
User: Dominique Dube

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PB67-43001-31

Job Number: 36349

Part Number: PB674300131

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MARK OUT BENDLINES & BEND ENDS 3.38" UP EACH SIDE
AS PER DWG B67-43001-31

Note: used to be made in three parts (-321 & -323) then welded, now it will be made as one part and bent.

Handwritten: 08.01.08 1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/06/08

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

MARK HOLES OFF B67-43001-33 Upper pad assy, BEFORE IT LEAVES FOR FOAM COVERING.

MARK 5 HOLES & DRILL Ø 0.193" AS PER DWG

Handwritten: 08.01.08 1

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/06/08

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE)

Handwritten: 08-01-09 (K)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-09-09

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Handwritten: M/102316

POWDER COAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8)

Handwritten: M-1 08/09/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 12:13:54 PM
User: Dominique Dube

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PB67-43001-31

Job Number: 36349

Part Number: PB674300131

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-09

(2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

IDENTIFY & PLACE IN STOCK

12/21/28

(1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12/21/28 (1)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

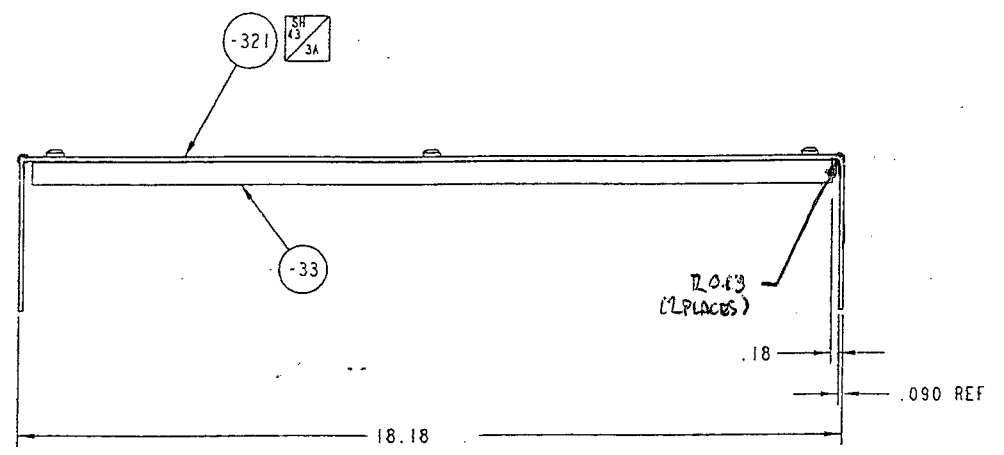
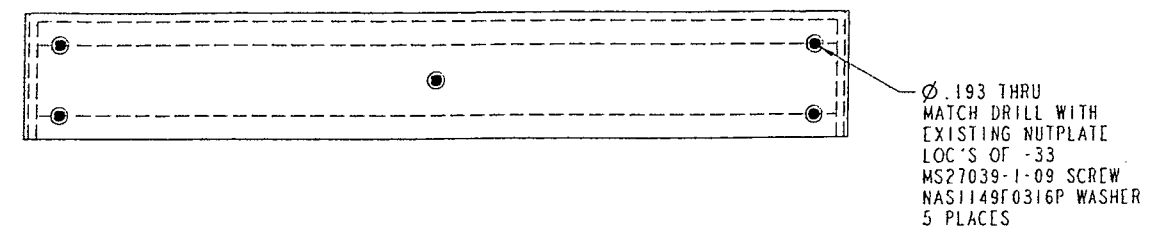
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QA: N/C Closed: _____ Date: _____

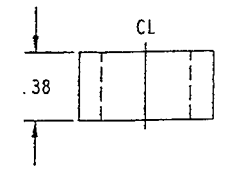
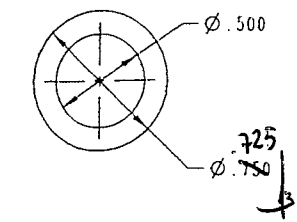
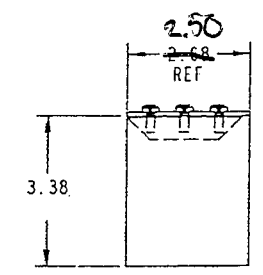
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

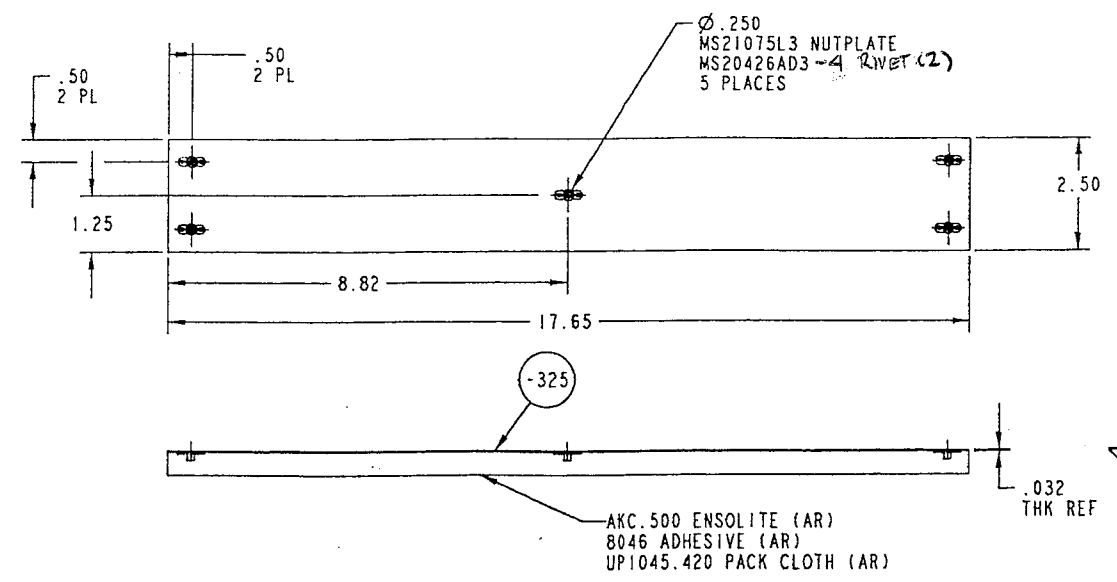
RELEASED
06.01.20



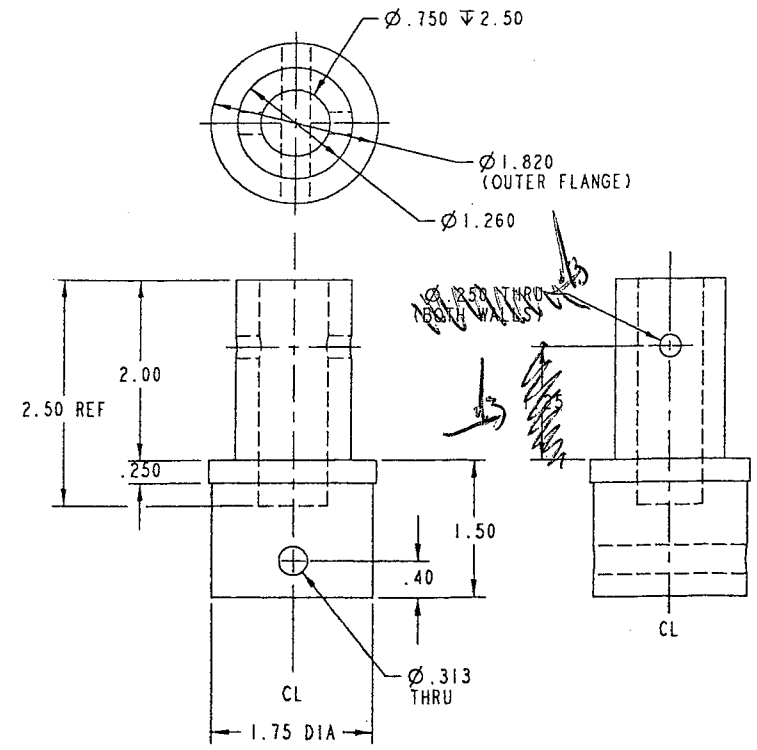
① -31 UPPER RESTRAINT WELDMENT
SCALE 0.500



④ -299 BUSHING
SCALE 2.000
MAT: 304 CRES, COND A



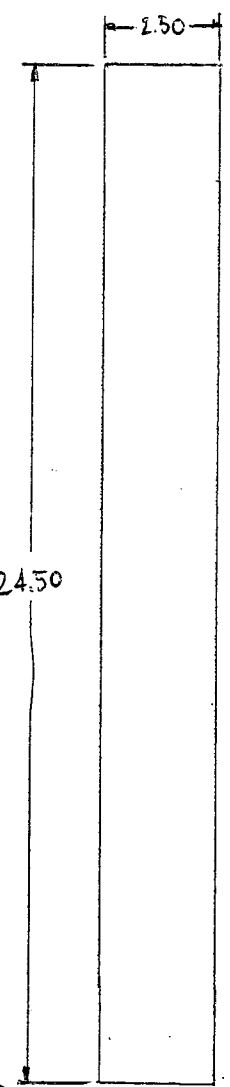
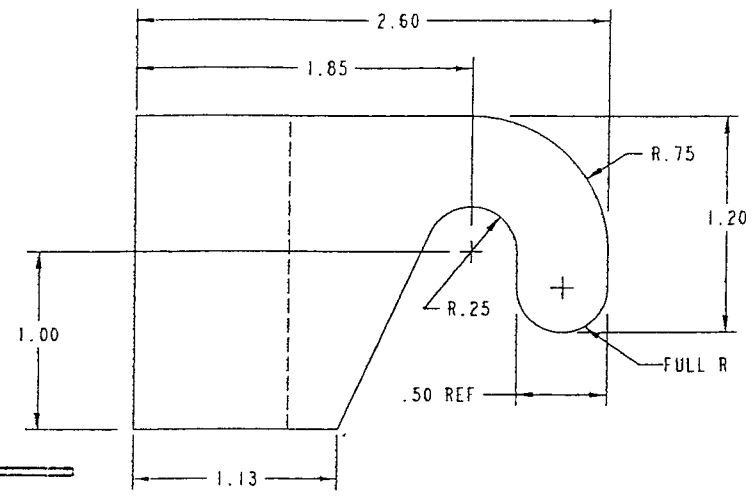
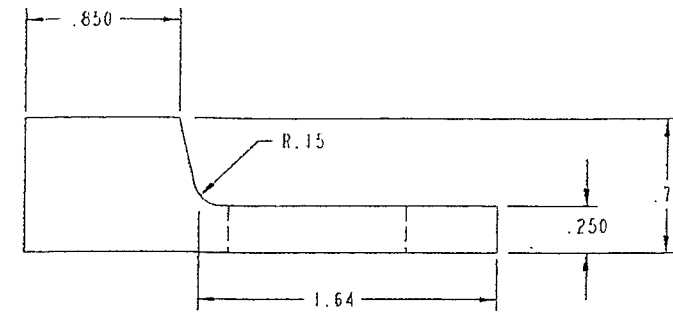
① -33 UPPER PAD ASSY
SCALE 0.500
MATL FOR -325: .032 THK 2024-T3 AL,
QQ-A-250/4



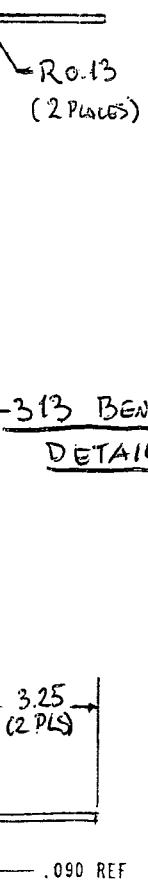
① -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL,
QQ-A-200/3

ORIGINAL

RELEASED
#06-01-20



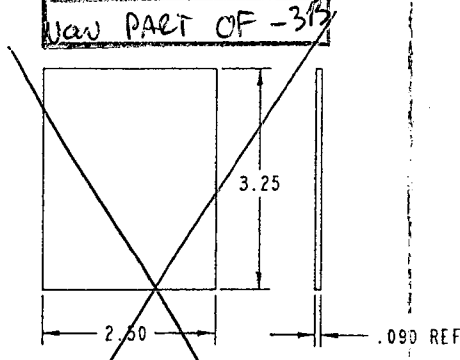
① -313 FLAT PATTERN
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



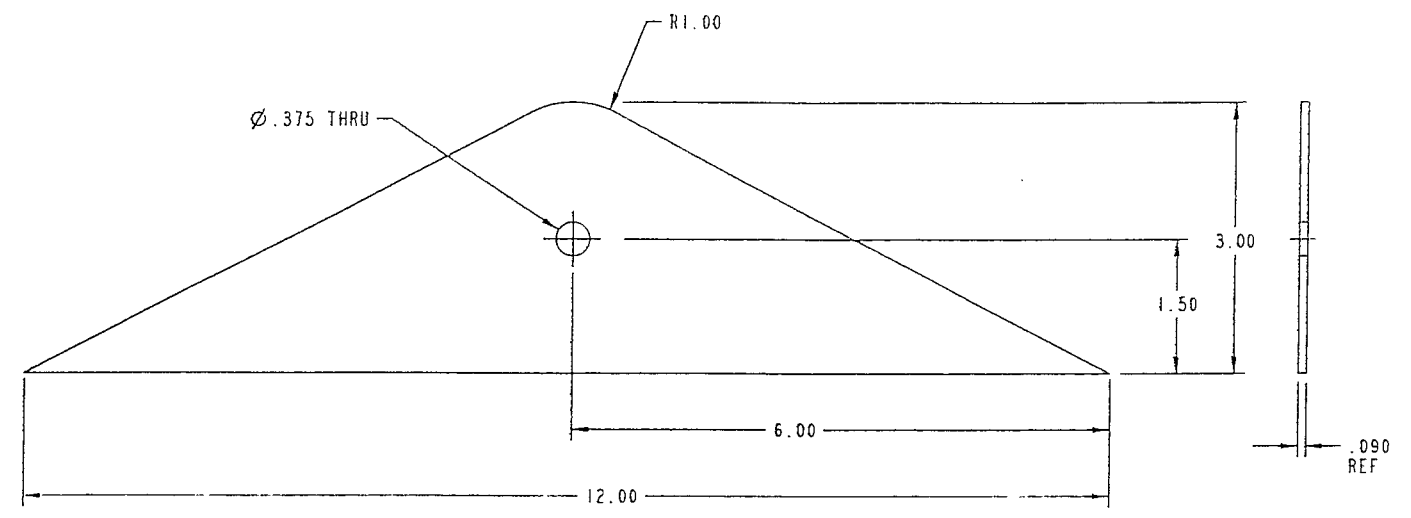
-313 BENDING
DETAIL

③ -315 HOOK
SCALE 2.000
MAT: 6061-T6 AL.
QQ-A-200/8

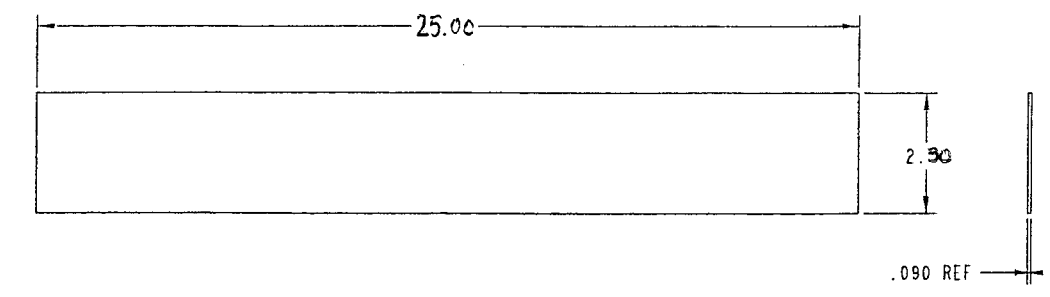
SUPERCEDED BY
New PART OF -313



② -317 PLATE
SCALE 0.750
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



② -319 GUSSET
SCALE 1.000
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



① -321 PLATE
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

REFINISHED ONLY

PREMIER AVIATION, INC.			
2621 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE IDENT NO.	DWG NO.	REV.
D	OSUV8	B67-43001	B1
SCALE:	WT:	SHEET	43 of 45

ORIGINAL

